

# Work Order ID 99226

April-03-13 1:07:33 PM

**\*99226\***

*Ship tomorrow* Page 1

Item ID: D4791-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: PRELIM Stop **\*NS2\***  
 Item Name: Aft C-Channel  
 Start Date: 4/03/13 Start Qty: ~~2.00~~ <sup>3</sup> **\*2\*** Cust Item ID:  
 Required Date: 4/03/13 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

**PRELIMINARY ISSUE**

Approvals: Process Plan: MP Date: 13-4-03 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4791	PA3

100	FLOW WATER JET	0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (D4791-4F) Dwg Rev: <u>PA3</u> Prog Rev: <u>PA3</u> 2-Deburr as required								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

**DAS**  
**05**  
**0-03** 13-04-03

**DAS**  
**05**  
**0-03** 13-04-03

# Work Order ID 99226

\*99226\*

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April-03-13 1:07:34 PM

Item ID: D4791-3 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: PRELIM Stop \*NS2\*  
 Item Name: Aft C-Channel  
 Start Date: 4/03/13 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 4/03/13 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00 27 134.3				3 Inspected as per Rung PAB			
140 *140* Brake NC Brake NC	Form as per dwg NC BRAKE  Memo Bend as per Dwg D4791	0.00 0.00				3			SB 3/04/04
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00 27 134.4				3 Inspected as per Rung PAB			

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Item ID: D4791-3

Revision ID: PRELIM

Item Name: Aft C-Channel

Start Date: 4/03/13

Start Qty: 2.00

**\*2\***

Required Date: 4/03/13

Req'd Qty: 2.00

**\*2\***

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Run Start

**\*NR1\***

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

**\*160\***

HandFinish

Memo

0.00

Hand Finishing

3 13.45

170

QC7-Inspect Chemical Conversion Coat

0.00

**\*170\***

QC

Memo

0.00

Quality Control

13.453

180

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

# Work Order ID 99226

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**\*99226\***

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Item ID: D4791-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID: PRELIM

Stop **\*NS2\***

Item Name: Aft C-Channel

Start Date: 4/03/13 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 4/03/13 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

*MF*  
*13 45*

# Picklist Print

April-03-13 1:07:33 PM

Page 1

Work Order ID: 99226

Parent Item: D4791-3

Parent Item Name: Aft C-Channel

Start Date: 4/03/13

Required Date: 4/03/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-03-22 JLM VERIFIED BY:DD  
REV.PA2 DD VERIFIED BY:JLM IPP REV:B 13-03-22 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No				sf	243.3625		0.6863158		13-04-03	

Location

MAT021

123135

124003

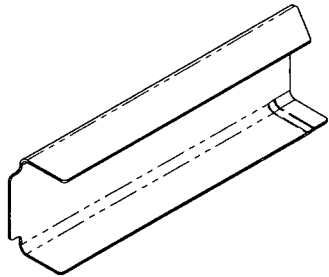
Loc Qty

243.3625

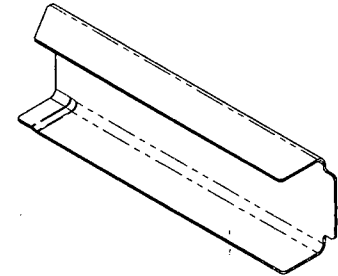
120.5625

122.8

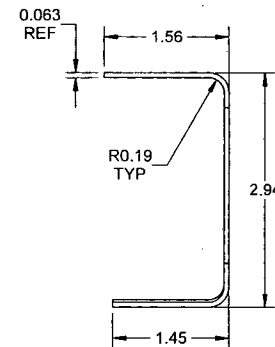
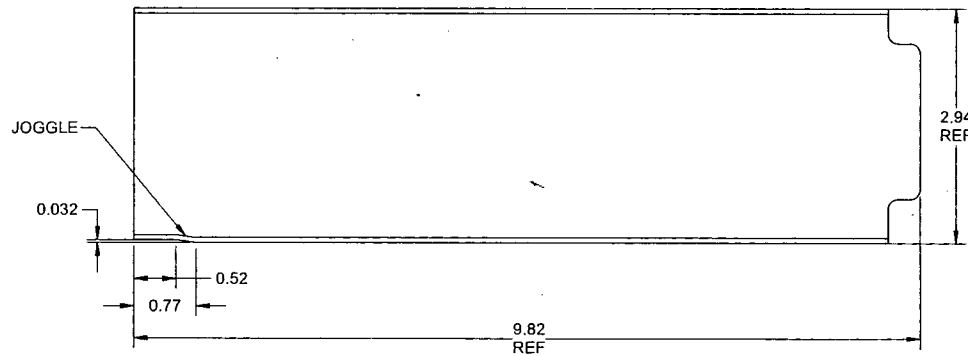
Loc Code



**D4791-4 AFT C-CHANNEL**  
ISO VIEW  
MAKE FROM D4791-4F



**D4791-3 AFT C-CHANNEL**  
ISO VIEW  
MAKE FROM D4791-4F



**D4791-3 AFT C-CHANNEL**

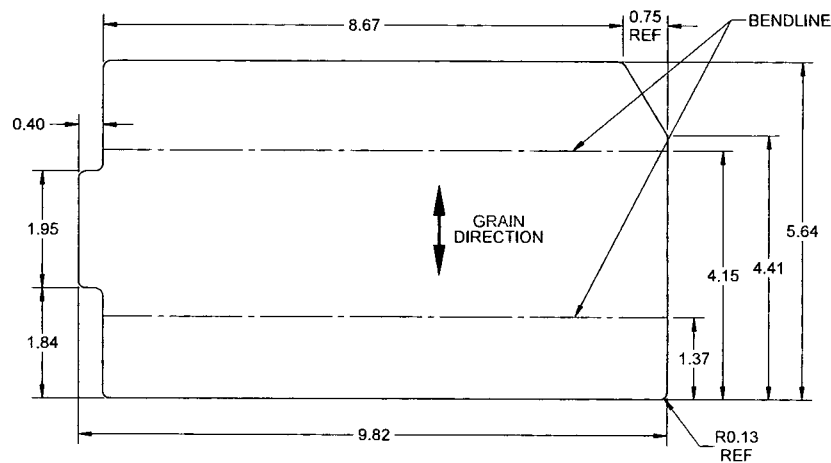
**PRELIMINARY ISSUE**

13.03.02

**NOTES:**

- 1) MATERIAL: MAKE FROM D4791-4F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO. <b>D4791</b>	REV. PA3
MFG. APPR.			SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>AFT C-CHANNEL ASSEMBLY</b>	NTS
DATE	13.03.02	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LENDED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD.</small>	



**D4791-4F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M2024T3S.063 OR M6061T6S.063  
OR  
2024-T3 ALUMINUM SHEET, 0.063 THICK  
QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF DART SPEC M6061T6S.063 OR M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.32 lbs

**PRELIMINARY ISSUE**

**13.03.02**

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>DC</i>	DRAWING NO. <b>D4791</b>	REV. PA3
MFG. APPR.		SHEET 9 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		<b>AFT C-CHANNEL ASSEMBLY</b>	
DATE	<b>13.03.02</b>	NTS	

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# Receiving Report

Date: 12-12-11  
 Supplier: Campi

Batch No: 124003  
 Dart P/O: 186008

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☒ No ☐  
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☒ N/A ☐  
 Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection ☒ N/A ☒  
 Work Order ☒ N/A ☒

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

SP

Production/Admin: 12-12-11  
 Date  
 Received/Costing SP  
 Initial

Location \_\_\_\_\_

## Page 1 of 1

All amounts are calculated in domestic currency.

Grouped by Vendor ID

<b>Total Received Quantity:</b>	288.0000
<b>Total Qty to Inspect (PO U/M):</b>	0.0000
<b>Total Reject Quantity:</b>	0.0000
<b>Total Receipt Value:</b>	\$978.22
<b>Total Balance Due Quantity:</b>	0.0000



**STEEL AND SPECIALTY METALS DISTRIBUTOR**

**FAX :** 1 866 456-4242

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY,  
ONTARIO  
K6A 1K7

DATE DE LIVRAISON 11/12/12  
DELIVERY DATE

SIGNATURE OF AGENT / CUSTOMER'S SIGNATURE

# CERTIFIED INSPECTION REPORT

**Alcoa Inc.**

**DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722**

**Ship From: RIVERDALE, IA.**

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per

*Rob Woodall*

Rob Woodall  
Director of Manufacturing Davenport Works

*Terence Thom*

Terence Thom  
Quality Assurance Manager

1381354

Ship Date

0

B.L. No.

Invoice No.

Alcoa No. Item

2012-05-16

7036272

00000

1000363803-3

DPE-63803-3

P.O. No./Govt Contract No.

Customer

Alcoa Item

C64813 Ln#: 3

Page 2 of 2

CQR: 0222751.7 -Specification Limits (cont.)

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other
Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Min	0.40		0.15		0.8	0.04				

Alloy 6061 - Mechanical, Physical, Metallography, Quantometer Results

Lot: 463274	No->	UTS	TYS	EL4D
Temp	Dir	KSI	KSI	PCT
T6	Long Transv.	51.1	44.8	12.1
		50.9	44.7	11.6
		51	44.7	11.5
		51	44.7	11
		51	44.7	12.2
		50.5	44	11.7
		50.7	44.4	11.3
		50.5	44.2	11.5
		50.5	44.2	11
		50.6	44.4	11.6

Cast Number	Chemical - QES	SI	FE	CU	MN	MG	CR	ZN	TI
H9479082	Actuals	0.66	0.4	0.27	0.06	0.9	0.17	0.03	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO18608**

Purchase Order Date 12/07/12

PO Print Date 12/07/12

Page Number 1 of 1

**Order From :**

VC-CAM002

CAMPI STEEL  
935 BOUL. DU HAVRE  
VALLEYFIELD, QC J6S 5L1  
CA

**Contact Name**

**Vendor Phone** 800 667 4248

**Vendor Fax** 450 377 5696

**Vendor Account Nbr**

**Buyer**

Chantal Lavoie

**Requisition Nbr**

**Tax Resale Nbr**

**Terms**

**Currency**

**FOB**

10127-2607

Net 30

CAD

Destination-Collect

**Ship To :**

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
COPY

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6S.063	6061-T6 .063 Sheet	12/17/12 Yes	288.00 sf	Yours ppd	\$3.3750	\$972.00

**Special Inst:** MATERIAL: 6061-T6/T62 ALUMINUM  
SHEET  
AS PER QQ-A-250/11 OR AMS-QQ-A-  
250/11 OR  
AMS 4025 OR AMS 4027 OR ASTM B209

NOTE: RECEIVING DEPARTMENT WILL  
BE CLOSE FOR INVENTORY ON  
DECEMBER 13 AND 14

8012-12-11

**PO Total:**

**\$972.00**

**MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY**

**Change Nbr:** 2

**Change Date:** 12/07/12

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required **YES** NO